

Date: Monday, 02/02/2009 12:39:49 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: NUT PLATE ASSEMBLY		
Job Number	: 45422			Part Number	: D2873043		
Estimate Number	: 11053			Drawing Number	: D2873 REVA		
P.O. Number	:			Project Number	: N/A		
This Issue	: 02/02/2009 S.O. No. :			Drawing Revision	: A		
Prsht Rev.	: NC			Material	:		
First Issue	: / / Type : MACHINED PARTS			Due Date	: 09/02/2009 Qty: 20 Um: Each		
Previous Run	: 45370						
Written By	:						
Checked & Approved By	: <u>JUL 09.02.09</u>						
Comment	: Est A05.09.13 New issue KJ/JLM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6B0375X01000	6061T6 BAR .375 x 1.00	
		Comment: Qty.: 0.3237 f(s)/Unit Total : 6.4743 f(s) 6061T6 BAR Material: 6061-T6 Bar (QQ-A-200/8 or QQ-A-225/8) (M6061T6B0.375x01.000) Identify for D2873-3 Batch: <u>M 110001</u>	 <i>mmr 09/02/09</i> 18
2.0	BAND SAW	BAND SAW	
		Comment: BAND SAW Cut blanks: 1.000" x 0.375" x 3.700" long	 <i>mmr 09/02/09</i> 18
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per Folio FA and Dwg D2873 Identify as D2873-3 Dwg Rev <u>A</u> Folio Rev <u>A</u>	 <i>mmr 09/02/09</i> 17
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	 <i>mmr 09/02/09</i> 17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2813-043 PAR #: N/A Fault Category: Prod / Machined P/B NCR: Yes No DQA: D Date: 09/03/03
 Resolution: SCRAP Disposition: SCRAP QA: N/C Closed: D Date: 09/03/03

NCR: 45422		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/02/05	3.0	Part thickness too small, Had to machine jaws to fix problem dimension 0.250 is 0.234	PJ QSI 042 09.02.05	PART IS SCRAP. B/C OUT OF TOLERANCE Scrap and destroy Qty 4 Amo 4000 No Material	MJ= 09/02/05	S 09/02/05	AS QSI 042 09.02.05	C 09/02/05
		PC Jaws were off.						

NOTE: Date & initial all entries

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Job Number: 45422		Part Number: D2873043
Job Number:		
Seq. #:	Machine Or Operation:	Description :
5.0	QC8	SECOND CHECK 
Comment: SECOND CHECK		<i>DP 09/02/06</i>
6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 
Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Deburr 2- C'sink as per Dwg D2873		<i>EP 09/02/10 (17)</i>
7.0	QC5	INSPECT WORK TO CURRENT STEP 
Comment: INSPECT WORK TO CURRENT STEP		<i>S 09/02/10 (x17)</i>
8.0	HAND FINISHING1	HAND FINISHING RESOURCE #1 
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1		<i>HS 09 - 02 - 10 (19)</i>
9.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION 
Comment: INSPECT CHEMICAL CONVERSION		<i>F1 09/02/10 (17)</i>
10.0	MS20426AD46	Rivet 
Comment: Qty.: 6.0000 Each(s)/Unit Total : 120.0000 Each(s) Rivet Pick; Qty Part Number Description Batch		<i>M105144 Ep 09/02/23</i>
11.0	MS21075L5	Nut Plate 
Comment: Qty.: 3.0000 Each(s)/Unit Total : 60.0000 Each(s) Nut Plate Pick; Qty Part Number Description Batch		<i>M110916 Ep 09/02/23</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE:-Date & initial all entries

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Job Number:		
Seq. #:	Machine Or Operation:	Description :
12.0	SMALL FAB 1 	SMALL & MEDIUM FAB RESOURCE 1 
<p>Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Assemble as per Dwg D2873 2-Identify as D2873-043</p> <p><i>Ep09/02/23 (12)</i></p>		
13.0	QC5 	INSPECT WORK TO CURRENT STEP 
<p>Comment: INSPECT WORK TO CURRENT STEP <i>3 09/02/23 (X12)</i></p>		
14.0	PACKAGING 1 	PACKAGING RESOURCE #1 
<p>Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <i>1 tube assy</i> <i>BT 09-02-25</i></p>		
15.0	QC21 	FINAL INSPECTION/W/O RELEASE  <i>09/02/26 HJ</i>
<p>Comment: FINAL INSPECTION/W/O RELEASE</p>		
Job Completion		 <i>U 09.02.25</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	W5422
Description: Radius Block	Part Number:	D2873-3
Inspection Dwg: D2873	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>MMJ</u>	Audited by:	<u>DH</u>	Prototype Approval:	N/A
Date:	09/02/05	Date:	09/02/06	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.08.30	New Issue P/O D2873-043	KJ/JLM	<i>[Signature]</i>

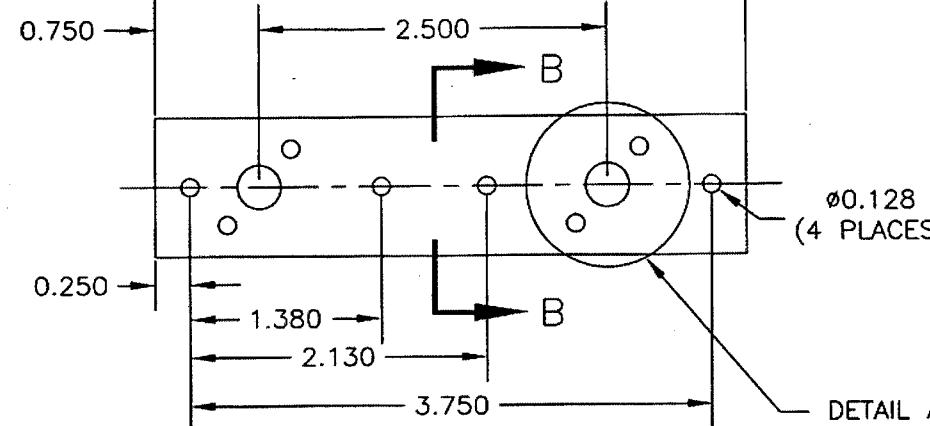
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

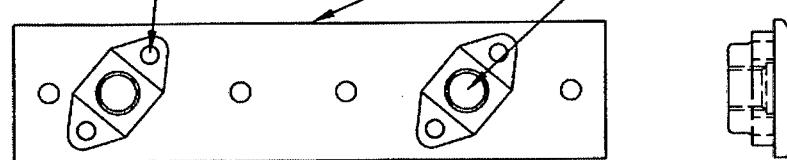
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

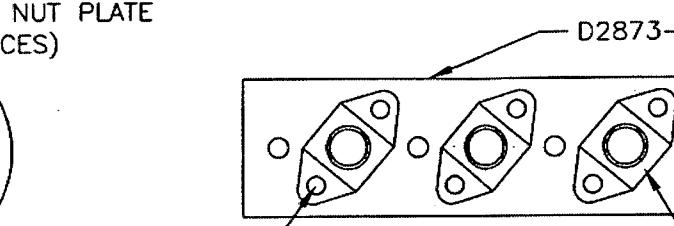
NOTE: Date & initial all entries



D2873-1
MS20426AD4-6
RIVET (TYP 4 PLACES)
D2873-1
MS21075L5 NUT PLATE
(TYP 2 PLACES)



D2873-041



D2873-043
MS20426AD4-6
RIVET (TYP 6 PLACES)

D2873-1/-3/-5 RADIUS BLOCK

- 1) MATERIAL: 5052-H32/H34 BAR (QQ-A-225/7) (REF. DART SPEC M5052H32B1.000X00.250) OR 6061-T6 BAR (QQ-A-225/8 OR QQ-A-200/8) (REF. DART SPEC M6061T6B1.000X00.250)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6) Ø0.128 PILOT + C'BORE CURVED SIDE Ø0.230X0.125 DEEP + C'SINK CURVED SIDE Ø0.225 x 100°

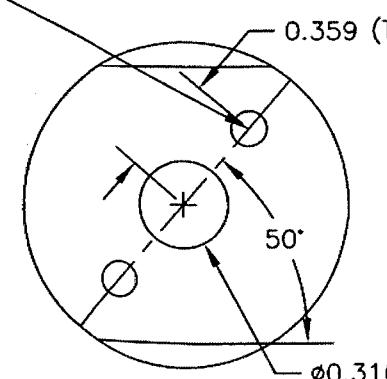
D2873-041/-043/-045 NUT PLATE ASSEMBLY

- 1) INSTALL MS21075L5 NUT PLATE IN ORIENTATION SHOWN USING MS20426AD4-6 RIVETS

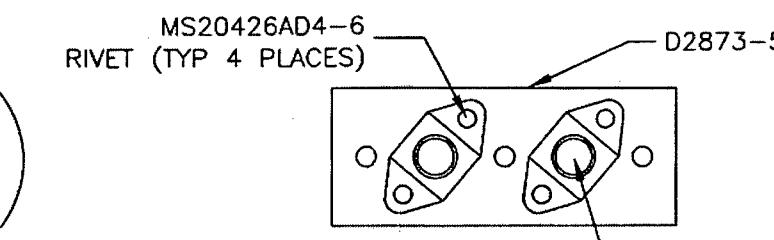
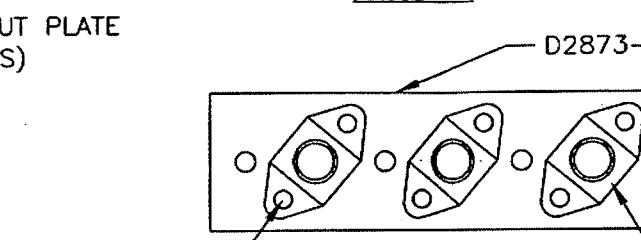
D2873-041/-043/-045 NUT PLATE ASSEMBLY PARTS LIST

-041	-043	-045	PART NUMBER	DESCRIPTION
X			D2873-041	NUT PLATE ASSEMBLY
	X		D2873-043	NUT PLATE ASSEMBLY
		X	D2873-045	NUT PLATE ASSEMBLY
1			D2873-1	RADIUS BLOCK
1			D2873-3	RADIUS BLOCK
	1		D2873-5	RADIUS BLOCK
4	6	4	MS20426AD4-6	RIVET
2	3	2	MS21075L5	NUT PLATE

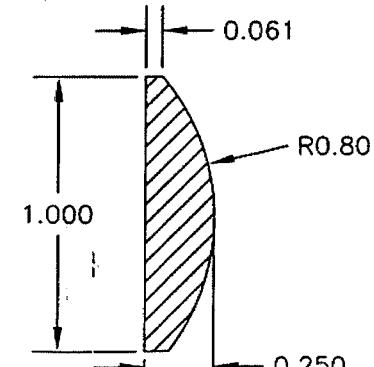
6
(-041 4 PLACES)
(-043 6 PLACES)
(-045 4 PLACES)



DETAIL A (SCALE 2.5)



D2873-045
MS21075L5 NUT PLATE
(TYP 2 PLACES)



SECTION B-B (SCALE 2:5)

RELEASED
65-0726

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

A	05.07.26	NEW ISSUE	NO. 15002
DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKSBURY, ONTARIO, CANADA	
CHECKED <input checked="" type="checkbox"/>	APPROVED <input checked="" type="checkbox"/>	DRAWING NO.	REV. A
DS	DS	D2873	SHEET 1 OF 1
DATE	TITLE	SCALE	
05.07.26	RADIUS BLOCK	4:5	